

**Work Order ID 71296**

Monday, June 27, 2011 12:57:51 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 6/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D135-751-011 CHG001

for BG 11-7-26

B71296

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****								
	7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892. Open holes to 0.297"								
	9-Open Aft & Fwd Cap holes using .208" drill.								
	10-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	11-Open ground wire hole .297" section E-E								
	12- Section G-G holes must be laid out manually, open to #30.								
	13-Deburr holes.								

1 0 BB11/07/11

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

S 11/2/19



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

①

B 11/07/19

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JD

11-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 117516  
Exp Date: 12/01/15  
start time: 12:35 PM  
end time: \_\_\_\_\_

OK 11/07/20

5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: 1112860

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

BE 11/07/21

BB 11/07/20

BB 11/07/21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

11/07/21

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

11/07/22

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/07/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 M 11/02/25

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

117745.

Memo

0.00

Powder Coating

START TIME: 9:50  
OVEN TEMPERATURE: 320°  
FINISH TIME: 10:20.

1 0 BK 11-7-25.

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 M 11/07/25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install Wearplate &amp; Ground Wire inserts as per Dwg D3507.

1- Inspect for Foreign objects

2- Install Fwd &amp; Aft caps as per Dwg D3507 And Detail "A" &amp; "B"

A/R 241 Sika Flex Batch: 11117516

Exp Date: 15/01

3- Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: 11117516

Exp Date: 15/01

4- Assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 11114189

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 11117863

1 of 11607125

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 6/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W 11 07 25 (1)

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/25

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W 11 07 25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

300

0.00



Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev: B

Packaging

310

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

11/7/26 (1)

11/7/26 (1)

11.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 27, 2011 12:57:59 PM

Page 1

Work Order ID: 71296

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation



Start Date: 6/27/2011

Required Date: 7/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130		Purchased	No				Each	1,247.000		38			
Insert													

Location	Loc Qty	Loc Code
ST282	1247	
117717	1247	M118386

Handwritten: 1107125

Handwritten: X38

D3507-1-BENT		Manufactured	No			120	Each	0.0000	1	1			

Handwritten: 371200 x1 8/11/07/18

Skidtube Assembly EC135													
D3504-1		Manufactured	No			170	Each	2.0000	2	2			

Handwritten: 371200 8/11/07/21  
 371130 x2

Location	Loc Qty	Loc Code
LG001	2	
53742	2	

D3504-3		Manufactured	No			170	Each	24.0000	1	1			

Handwritten: 371130 8/11/07/21

Location	Loc Qty	Loc Code
LG001	24	
31232	4	
53743	20	

Handwritten: 1

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-5 Manufactured No

170 Each

4.0000

2

2



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

4

53744

4

D3505-1 Manufactured No

170 Each

1.0000

1

1



Web

Location

Loc Qty

Loc Code

LG

1

71214

1

D3506-1 Manufactured No

190 Each

39.0000

4

4



Doubler

Location

Loc Qty

Loc Code

ST063

39

51789

39

D3506-3 Manufactured No

190 Each

83.0000

2

2



Doubler

Location

Loc Qty

Loc Code

ST063

83

51790

83

MS20601-AD4W3 Purchased No

190 Each

2,822.000

12

12



Rivet

Location

Loc Qty

Loc Code

ST321

2822

114538

2822

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Shop Packet Print

Page 2

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Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 Purchased No

260 Each

729.0000

1

1



11/07/25

Insert

Location

Loc Qty

Loc Code

ST282

729

110768

213

117717

516

x1

AN3C4A Purchased No

260 Each

2,235.000

31

31



11/07/25

BOLT

Location

Loc Qty

Loc Code

ST350

2235

117094

8

117313

2

117688

784

117795

500

117872

22

118012

500

118112

419

x31

AN3C5A Purchased No

260 Each

1,401.000

2

2



11/07/25

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1394

116419

28

116549

54

117343

500

117508

12

117764

300

117872

500

y2

Monday, June 27, 2011 12:58:00 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 27, 2011 12:58:00 PM

Work Order ID: 71296

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10 Purchased No

260

Each

243.0000

2

2



Screw



HL 11/07/25

Location

Loc Qty

Loc Code

FP-B

105

108062

105

ST327

100

114494

100

ST328

38

110049

38

x2

AN960C10L NAS1149C0332 Purchased No

R

260

Each

0.0000

33

33



washer

D2965

Manufactured No

260

Each

24.0000

1

1



Cap, 105 Skidtube



HL 11/07/25

Location

Loc Qty

Loc Code

FP006

24

52057

24

D2965-3

Manufactured No

260

Each

2.0000

1

1



Cap



HL 11/07/25

Location

Loc Qty

Loc Code

FP005

2

50560

1

52282

1

1371300

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Monday, June 27, 2011 12:58:00 PM

Work Order ID: 71296

Parent Item: D135-751-011


Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011


Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No 260 Each 144.0000 4 4  
  
 Plug


Location	Loc Qty	Loc Code
FP	144	
69531	8	
69819	60	
70689	76	

D3492-3 Manufactured No 260 Each 136.0000 4 4  
  
 Plug

Location	Loc Qty	Loc Code
FP	136	
69822	56	
70692	80	


                      
                      
                      
                    

D3492-7 Manufactured No 260 Each 0.0000 2 2  
  
 Plug

D3492-047


328961

D3508-1 Manufactured No 260 Each 11.0000 1 1  
  
 Wearplate

Location	Loc Qty	Loc Code
FP016	11	
61020	11	

D3508-3 Manufactured No 260 Each 3.0000 1 1  
  
 Wearplate

Location	Loc Qty	Loc Code
FP021	3	
38527	1	
67489	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Monday, June 27, 2011 12:58:01 PM

Work Order ID: 71296

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011



Start Qty: 1.00

Required Qty: 1.00

D3508-5	Manufactured	No	260	Each	5.0000	1	1
							<u>HL 11/07/25</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	5	
67160	5	<u>XL</u>

D3508-7	Manufactured	No	260	Each	10.0000	1	1
							<u>HL 11/07/25</u>
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	10	
67159	4	<u>XL</u>
67739	6	

D3558-1	Manufactured	No	260	Each	11.0000	1	1
							<u>HL 11/07/25</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP014	11	
42533	1	
50925	10	<u>XL</u>

D3558-3	Manufactured	No	260	Each	5.0000	1	1
							<u>HL 11/07/25</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP014	5	1371661
67486	5	<u>XL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Monday, June 27, 2011 12:58:01 PM

Work Order ID: 71296

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/27/2011



Required Date: 7/5/2011

Start Qty: 1.00



Required Qty: 1.00

D3558-5      Manufactured      No      260      Each      13.0000      1      1  
  yl 11/07/25  
 Gasket



Location	Loc Qty	Loc Code
FP014	13	
43244	1	
67485	12	

D3558-7      Manufactured      No      260      Each      15.0000      1      1  
  yl 11/07/25  
 Gasket

Location	Loc Qty	Loc Code
FP014	15	
67162	15	

NAS1611-007      Purchased      No      260      Each      292.0000      2      2  
  yl 11/07/25  
 O-RING

Location	Loc Qty	Loc Code
FP-A	292	
103697	292	

NAS1611-010      Purchased      No      260      Each      210.0000      4      4  
  yl 11/07/25  
 O-RING

Location	Loc Qty	Loc Code
FP	96	
117460	16	
118077	80	
FP-A	114	
110915	95	
115589	19	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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Monday, June 27, 2011 12:58:01 PM

Page 8

Work Order ID: 71296

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/27/2011

Required Date: 7/5/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

188.0000

4

4



O-RING



11/10/125

## Location

## Loc Qty

## Loc Code

FP

183

117291

43

117887

140

FP-A

5

116582

5

AN3C4A

Purchased

No

280

Each

2,235.000

8



BOLT



## Location

## Loc Qty

## Loc Code

ST350

2235

117094

8

117313

2

117688

784

117795

500

117872

22

118012

500

118112

419

AN960C10L

NAS1149C0332  
R

Purchased

No

280

Each

0.0000

8

8



washer

D3512-1

Manufactured

No

280

Each

7.0000

2

2



Wearplate



1118306

71592 11/7/258

## Location

## Loc Qty

## Loc Code

ST500

7

70863

7

Monday, June 27, 2011 12:58:01 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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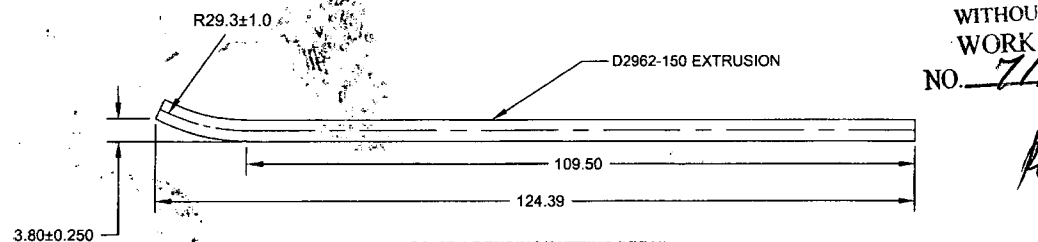
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71294  
11-06-27

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20501AD4W3	RIVET

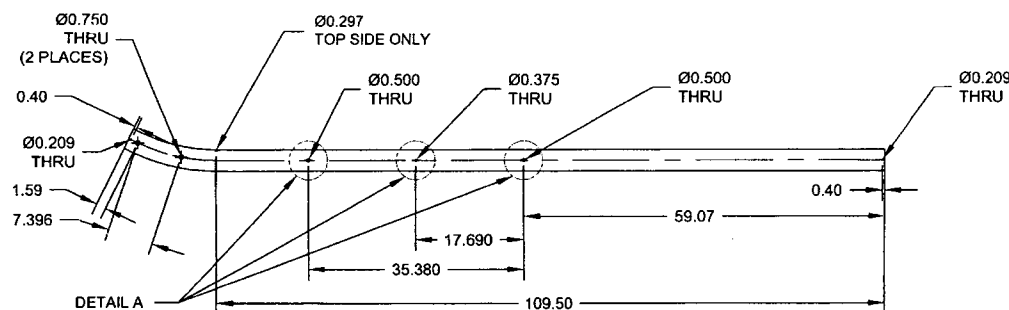
#### GENERAL NOTES:

- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING  
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER  
DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND  
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER  
DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38  
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38  
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED  
LOCATIONS

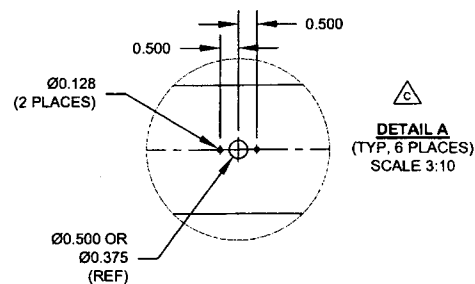
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	BP		
APPROVED	PH		
DE APPR.	PH	DRAWING NO. D3507	REV. C SHEET 1 OF 2
DATE	07.09.19	TITLE EC 135 SKIDTUBE	SCALE NTS
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A  
(TYP, 6 PLACES)  
SCALE 3:10

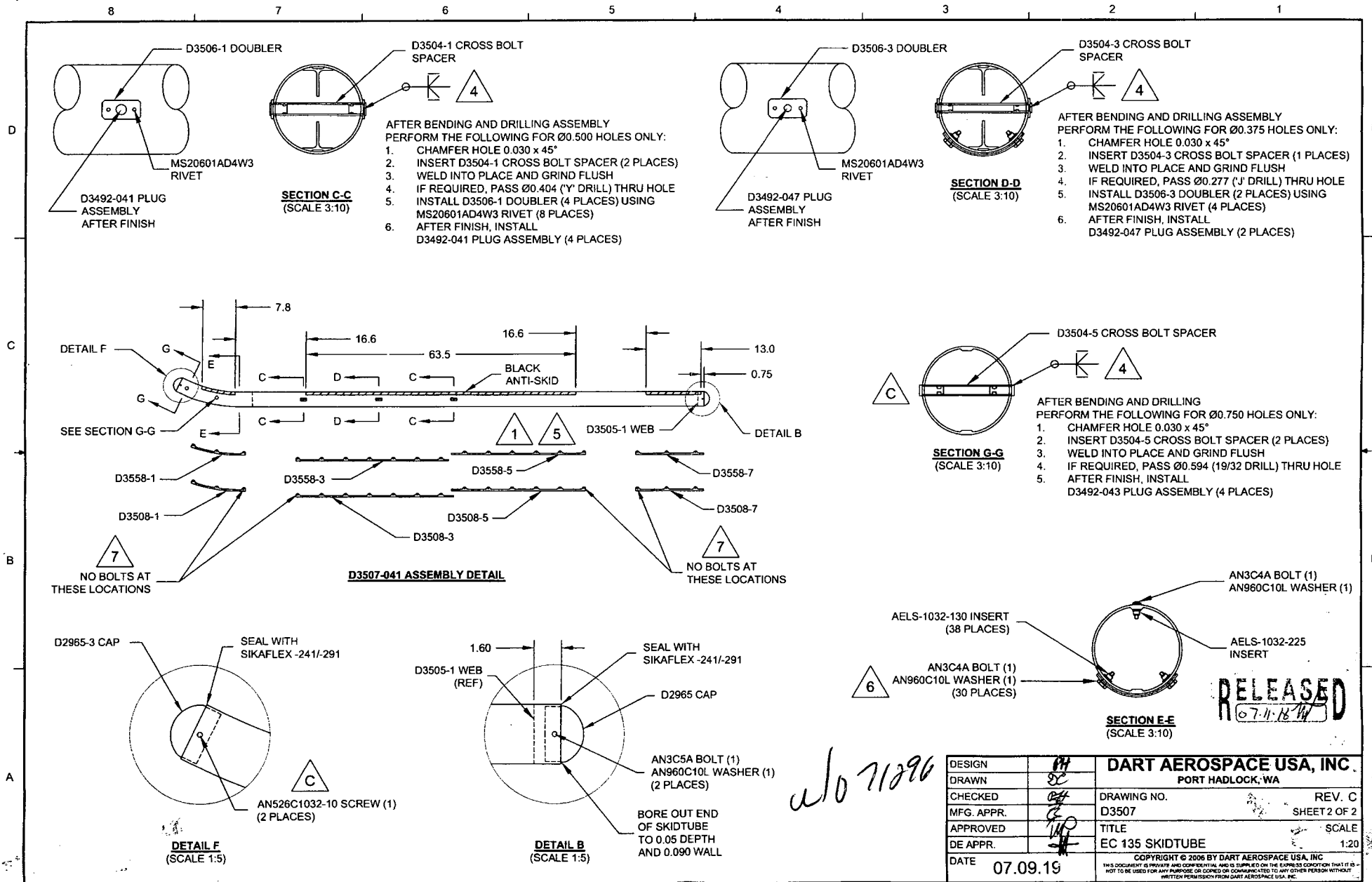
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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